

Work Order ID 96707

January-31-13 9:50:25 AM

96707**Blue**

Page 1

| | | | | | | | |
|----------------|--------------------------|----------------------|---------------------|------------|---------------|--------------|--------------|
| Item ID: | D2933-1 | Accept | *N900040100* | Setup | Start | *NS1* | |
| Revision ID: | | | | | | *NS2* | |
| Item Name: | Saddle LH In. 206 | | | | | | |
| Start Date: | 1/31/13 | Start Qty: | 2.00 | *2* | Cust Item ID: | | |
| Required Date: | 2/06/13 | Req'd Qty: | 2.00 | *2* | Customer: | | |
| Reference: | | | | | | | |
| Approvals: | Process Plan: <u>MLO</u> | Date: <u>1-30-13</u> | Tooling: | Date: | Run | Start | *NR1* |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | *NR2* |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|----------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|------------------------------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| 100 *100* HAAS I | HAAS CNC VERTICAL MACHINING #1 | 0.00 | | | | | | | <i>(2)</i> |
| HAAS CNC vertical machine #1 | Memo | 0.00 | | | | | | | <i>DAS 25 0-89 13-2-13</i> |
| 110 *110* Mill Conv | CONVENTIONAL MILLING MACHINE | 0.00 | | | | | | | <i>Z P</i> |
| Conventional Milling Machine | Memo | 0.00 | | | | | | | <i>DAS 25 0-89 13-2-13</i> |
| 120 *120* QC | QC1- Inspect dimensions to dimension sheet | 0.00 | | | | | | | <i>2 Ø</i> |
| Quality Control | Memo | 0.00 | | | | | | | <i>DAS 25 0-89 13-2-13</i> |

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | |
|-------------------|---|---|--|---|---|--|--------------------------------------|--------------|--------------|--|
| | | | Rework <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | |
| | | | Scrap <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | |
| | | | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | |
| | | | Work Order Update <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | |
| Doc/Data | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | |
| Operator | | | | | | | | | | |
| Material | | | | | | | | | | |
| Setup | | | | | | | | | | |
| Other | | | | | | | | | | |
| Process | | | | | | | | | | |
| Supplier | | | | | | | | | | |
| Training | | | | | | | | | | |
| Unapproved | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | |
| Landing Gear | General | | | | | | | | | |
| | Bending <input type="checkbox"/> | Bend <input type="checkbox"/> | Grain <input type="checkbox"/> | Ovalized <input type="checkbox"/> | Pressure/Forced <input type="checkbox"/> | | | | | |
| | Centre Not Concentric to O/S <input type="checkbox"/> | BOM/Route <input type="checkbox"/> | Hardware <input type="checkbox"/> | Over/Under tolerance <input type="checkbox"/> | Temperature/Cure <input type="checkbox"/> | | | | | |
| | Cracks <input type="checkbox"/> | Broken/Damaged <input type="checkbox"/> | Inspection Incomplete <input type="checkbox"/> | Part Incorrect <input type="checkbox"/> | Weld <input type="checkbox"/> | | | | | |
| | Crushed/Crimped. <input type="checkbox"/> | Burrs <input type="checkbox"/> | Instructions Incomplete/Unclear <input type="checkbox"/> | Part Lost/Missing <input type="checkbox"/> | Wrong Stock Pulled <input type="checkbox"/> | | | | | |
| | Cuffs <input type="checkbox"/> | Contamination <input type="checkbox"/> | Maintenance <input type="checkbox"/> | Part Moved <input type="checkbox"/> | | | | | | |
| | Heat Treat <input type="checkbox"/> | Countersink <input type="checkbox"/> | Mislabeled <input type="checkbox"/> | Positioned Wrong <input type="checkbox"/> | | | | | | |
| | Inspection Strip in Tube <input type="checkbox"/> | Cut Too Short <input type="checkbox"/> | Misread <input type="checkbox"/> | Power Loss/Surge <input type="checkbox"/> | | | | | | |
| | Ripples in Bend <input type="checkbox"/> | Drill Holes <input type="checkbox"/> | Offset <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | |
| | Torque Waves in Extrusion <input type="checkbox"/> | Drawing <input type="checkbox"/> | Out of Calibration <input type="checkbox"/> | | | | | | | |
| | Turning Sequence <input type="checkbox"/> | Finish <input type="checkbox"/> | Out of Sequence <input type="checkbox"/> | | | | | | | |
| | Wave/Twist in Tube <input type="checkbox"/> | Folio <input type="checkbox"/> | Outside Dimensions <input type="checkbox"/> | | | | | | | |

Work Order ID 96707

January-31-13 9:50:25 AM

96707

Page 2

Item ID: D2933-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Saddle LH In. 206

Stop

NS2

Start Date: 1/31/13 Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/06/13 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Quality Control

Fk 13/02/13

2 0

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Hand Finishing

Memo

0.00

2 13-2-14

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> | | | | | | | | | |
|---|------|------|-----|---|--|---|--------------------|--|-------------|--------------|--------------|--|--|---|--|
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | | Sign & Date | Verification | QC Inspector | | | | |
| Doc/Data | | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | | | | |
| Other | | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled | |

Work Order ID 96707

January-31-13 9:50:25 AM

96707

Page 3

Item ID: D2933-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Saddle LH In. 206

Stop

NS2

Start Date: 1/31/13 Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/06/13 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

145

Spray Painting per QSI005 4.2

0.00

2 Ø Ø Al 13-2-17

145

SprayPaint

Spray Painting

Memo

0.00

PRIME B 117319

START: 6:00

FINISH: 6:45

DELFLEET BLUE B 121722
DELFLEET CLEAR B 118093

START: 12:45

FINISH: 1:30

155

QC14- Inspect Spray Paint

0.00

DAS 1
05
9:09 13-02-19

155

QC

Quality Control

Memo

0.00

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | |
|-------------------|------------------------------|--|--|---|--|--------------------------------------|-------------|--------------|--------------|
| Part No. _____ | | Rework <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | |
| NCR No. _____ | | Scrap <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | |
| | | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | |
| | | Work Order Update <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Operator | | | | | | | | | |
| Material | | | | | | | | | |
| Setup | | | | | | | | | |
| Other | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Unapproved | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | |
| Landing Gear | Bending | General | | Grain | Ovalized | Pressure/Forced | | | |
| | Centre Not Concentric to O/S | | | Hardware | Over/Under tolerance | Temperature/Cure | | | |
| | Cracks | | | Inspection Incomplete | Part Incorrect | Weld | | | |
| | Crushed/Crimped. | | | Instructions Incomplete/Unclear | Part Lost/Missing | Wrong Stock Pulled | | | |
| | Cuffs | | | Maintenance | Part Moved | | | | |
| | Heat Treat | | | Mislabeled | Positioned Wrong | | | | |
| | Inspection Strip in Tube | | | Misread | Power Loss/Surge | | | | |
| | Ripples in Bend | | | Offset | | Other | | | |
| | Torque Waves in Extrusion | | | Out of Calibration | | | | | |
| | Turning Sequence | | | Out of Sequence | | | | | |
| | Wave/Twist in Tube | | | Outside Dimensions | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

Work Order ID 96707

January-31-13 9:50:25 AM

96707

Page 4

Item ID: D2933-I

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Saddle LH In. 206

Stop

NS2

Start Date: 1/31/13 Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/06/13 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location:

ST 400

0.00

170

Packaging

Memo

0.00

*2**SP*

Packaging

13-2-20

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

13/2/2013

Quality Control

MB.0.26

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | |
|-------------------|---|--|--|---|--|------------------------------------|---|--------------------------------------|--------------|
| | | Rework <input type="checkbox"/> | Scrap <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Machining <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | |
| | | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Finishing <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | |
| | | Work Order Update <input type="checkbox"/> | | Composite <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Supplier <input type="checkbox"/> | Other <input type="checkbox"/> | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Operator | | | | | | | | | |
| Material | | | | | | | | | |
| Setup | | | | | | | | | |
| Other | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Unapproved | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | |
| Landing Gear | General | | | | | | | | |
| | Bending <input type="checkbox"/> | Bend <input type="checkbox"/> | Grain <input type="checkbox"/> | Ovalized <input type="checkbox"/> | Pressure/Forced <input type="checkbox"/> | | | | |
| | Centre Not Concentric to O/S <input type="checkbox"/> | BOM/Route <input type="checkbox"/> | Hardware <input type="checkbox"/> | Over/Under tolerance <input type="checkbox"/> | Temperature/Cure <input type="checkbox"/> | | | | |
| | Cracks <input type="checkbox"/> | Broken/Damaged <input type="checkbox"/> | Inspection Incomplete <input type="checkbox"/> | Part Incorrect <input type="checkbox"/> | Weld <input type="checkbox"/> | | | | |
| | Crushed/Crimped. <input type="checkbox"/> | Burrs <input type="checkbox"/> | Instructions Incomplete/Unclear <input type="checkbox"/> | Part Lost/Missing <input type="checkbox"/> | Wrong Stock Pulled <input type="checkbox"/> | | | | |
| | Cuffs <input type="checkbox"/> | Contamination <input type="checkbox"/> | Maintenance <input type="checkbox"/> | Part Moved <input type="checkbox"/> | | | | | |
| | Heat Treat <input type="checkbox"/> | Countersink <input type="checkbox"/> | Mislabeled <input type="checkbox"/> | Positioned Wrong <input type="checkbox"/> | | | | | |
| | Inspection Strip in Tube <input type="checkbox"/> | Cut Too Short <input type="checkbox"/> | Misread <input type="checkbox"/> | Power Loss/Surge <input type="checkbox"/> | | | | | |
| | Ripples in Bend <input type="checkbox"/> | Drill Holes <input type="checkbox"/> | Offset <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | |
| | Torque Waves in Extrusion <input type="checkbox"/> | Drawing <input type="checkbox"/> | Out of Calibration <input type="checkbox"/> | | | | | | |
| | Turning Sequence <input type="checkbox"/> | Finish <input type="checkbox"/> | Out of Sequence <input type="checkbox"/> | | | | | | |
| | Wave/Twist in Tube <input type="checkbox"/> | Folio <input type="checkbox"/> | Outside Dimensions <input type="checkbox"/> | | | | | | |

Picklist Print

January-31-13 9:50:29 AM

Page 1

Work Order ID: 96707

96707
D2933-1

Parent Item: D2933-1

Parent Item Name: Saddle LH In. 206

Start Date: 1/31/13

Required Date: 2/06/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: B00.06.26New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|----------|
| D6101-001 | | Manufactured | No | | | 100 | Each | 83.0000 | 1 | 2 | ** | PJ | 13/02/06 |

D6101-001

Saddle Billet

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT040 | 33 | |
| 91236 | 33 | |
| MAT042 | 50 | |
| P 94445 | 50 | 2 |

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | |
|--|------|------|---|--|--|--|---------------------------------|--------------|--------------|--|--|
| | | | Rework Scrap Use-as-is Work Order Update | Skid-tube Machining Thermoforming Large Fab | Crosstube Small Fab Finishing Composite | Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier | Engineering Quality Other | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | |
| Operator | | | | | | | | | | | |
| Material | | | | | | | | | | | |
| Setup | | | | | | | | | | | |
| Other | | | | | | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | |
| Training | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <hr/> <hr/> | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <hr/> <input type="checkbox"/> Other |

| | | |
|---|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 96707 |
| Description: 206 Saddle, Inboard, Left side | Part Number: | D2933-1 |
| Inspection Dwg: D2933 Rev: C DSK: Rev: | | Page 1 of 1 |

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

| Dim | Min | Max | Go/No Go Gauge | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|---|---|---|
| | | | | 1 | 2 | 3 | 4 | 5 |
| A | 0.100 | 0.140 | | .115 | .115 | | | |
| B | 0.100 | 0.140 | | .115 | .115 | | | |
| C | 0.100 | 0.140 | | .117 | .117 | | | |
| D | 0.210 | 0.230 | | .220 | .220 | | | |
| E | 1.245 | 1.255 | | 1.250 | 1.250 | | | |
| F | 1.245 | 1.255 | | 1.250 | 1.250 | | | |
| G | 2.495 | 2.505 | | 2.500 | 2.500 | | | |
| H | 0.510 | 0.515 | | .510 | .510 | | | |
| I | 1.572 | 1.582 | | 1.577 | 1.577 | | | |
| J | 2.495 | 2.505 | | 2.500 | 2.500 | | | |
| K | 0.257 | 0.262 | | .258 | .258 | | | |
| L | 0.312 | 0.317 | | .313 | .313 | | | |
| M | 0.235 | 0.240 | | .238 | .238 | | | |
| N | 0.100 | 0.140 | | .120 | .120 | | | |
| O | 0.540 | 0.560 | | .551 | .552 | | | |
| P | 0.490 | 0.510 | | .500 | .499 | | | |
| Q | 3.715 | 3.725 | | 3.720 | 3.720 | | | |
| R | 2.470 | 2.510 | | 2.490 | 2.490 | | | |
| S | 0.240 | 0.270 | | .251 | .251 | | | |
| T | 0.100 | 0.180 | | .130 | .130 | | | |
| U | 1.625 | 1.635 | | 1.630 | 1.630 | | | |
| V | 1.362 | 1.372 | | 1.367 | 1.367 | | | |
| W | 0.316 | 0.321 | | .316 | .316 | | | |
| X | 1.125 | 1.145 | | 1.135 | 1.135 | | | |
| Y | 1.565 | 1.585 | | 1.575 | 1.575 | | | |
| Z | 0.178 | 0.198 | | .188 | .188 | | | |
| AA | | | | | | | | |
| AB | | | | | | | | |
| AC | | | | | | | | |
| AD | | | | | | | | |
| AE | | | | | | | | |
| Accept/Reject | | | | | | | | |

Measured by: JL

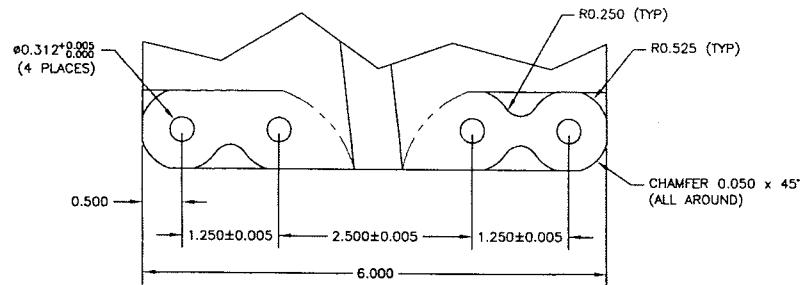
Date: 13-2-13

Audited by: F.K.

Date: 13/02/13

Prototype Approval: N/A Date: N/A

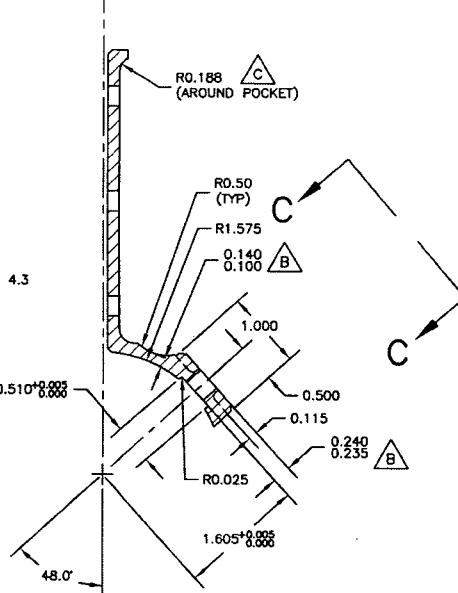
| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|--------------------|-----------|
| A | | New Issue | RF | |
| B | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B | KJ/RF | |
| C | 06.10.03 | Removed DT8683, DT8686 & DT8690 | KJ/JLM | |
| D | 07.03.21 | Revised per drawing revision C | KJ/JLM | |
| E | 08.01.16 | DT8695 A/B removed from dimension Y | KJ/EC/DD <u>JL</u> | <u>DS</u> |



VIEW C-C

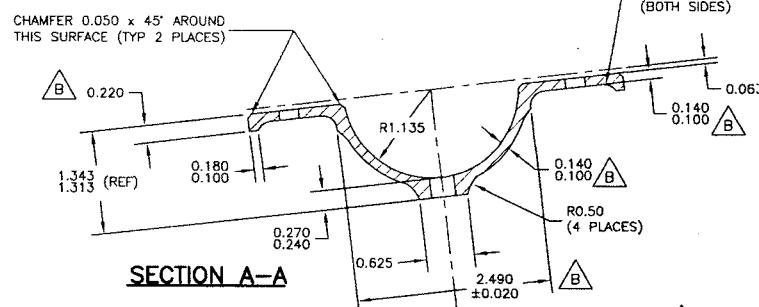
D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

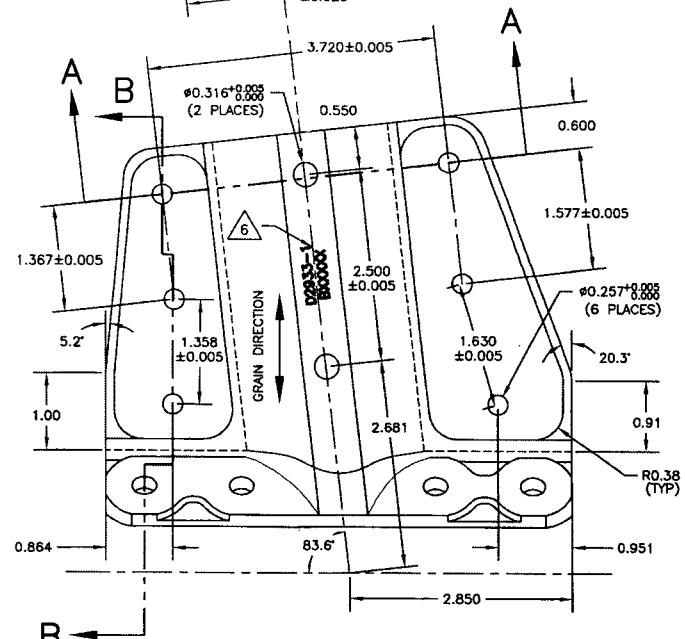


SECTION B-B

07.02.12



SECTION A-A



| | | |
|---------|----------|---|
| C | 06.11.09 | R0.188 WAS R0.30 TO R0.25 |
| B | 00.05.29 | CHANGED GEOMETRY AND MATERIAL |
| A | 99.10.29 | NEW ISSUE |
| DESIGN | DRAWN BY | DART DART AEROSPACE USA, INC. BELLEVUE, WA |
| CHECKED | APPROVED | DRAWING NO. D2933 REV. C SHEET 1 OF 1 |
| DATE | | TITLE SADDLE INSIDE SCALE 2:3 |

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